

Date: Wednesday, 9/19/2007 2:59:09 PM
 User: Chantal Lavoie

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 3" OUTER TUBE		
Job Number	: 34715			Part Number	: D26001160		
Estimate Number	: 10053			Drawing Number	: D2600 REV D1		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 9/19/2007	S.O. No.	: N/A	Drawing Revision	: D1		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 9/28/2007		
Previous Run	: 30249			Qty:	98	Um:	Each
Written By							
Checked & Approved By							
Comment	: Est. D: 02.09.05 Added DSK 066 KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING Comment: PURCHASING Issue P/O: <i>4623</i> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 160" long g) Bon L Canada Inc. tool # 897121 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required <i>c 207/09/19</i> <i>(110)</i>
2.0	D26001160P	Extrusion Round 3" 206 Comment: Qty.: 1.0000 Each(s)/Unit Total: 110.0000 Each(s) Extrusion Round 3" 206 <i>(110)</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>G 207/09/01 (98)</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/19/2007 2:59:10 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" OUTER TUBE

Job Number: 34715

Part Number: D26001160

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2600

Check Pull test per Dwg D2600 for compliance page attached

Check hardness with Webster tester



counter
07/10/03 (X88)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____



7/10/9 SG (98)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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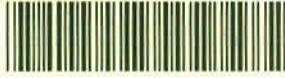


Comment: FINAL INSPECTION/W/O RELEASE



(98)
07/10/11

Job Completion



W 07/10/10

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART
RELEASED
 18.08.25 DS

DESIGN <i>DRY</i>	DRAWN BY <i>DRY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>S</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
M	01.04.17	ADD PART NUMBERS + DIE NUMBERS	<i>FOP</i>

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.

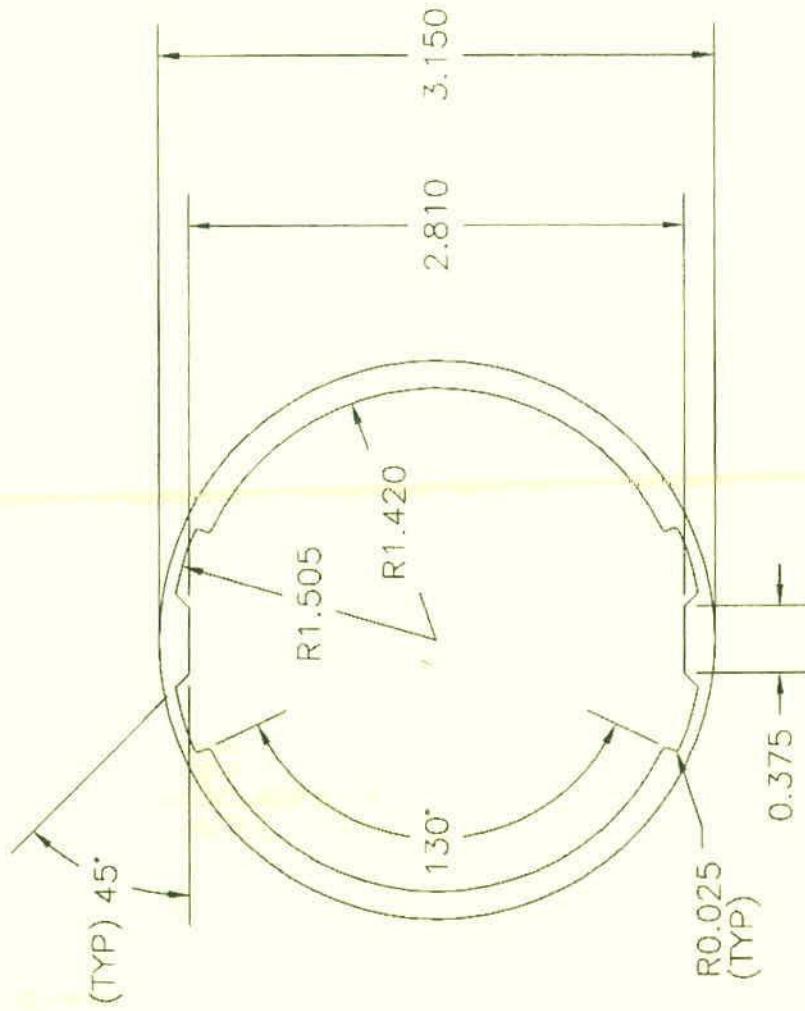
3. NO TOOLING MARKS.

4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED.

5. ALL DIMENSIONS ARE IN INCHES.

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DSD2600-3

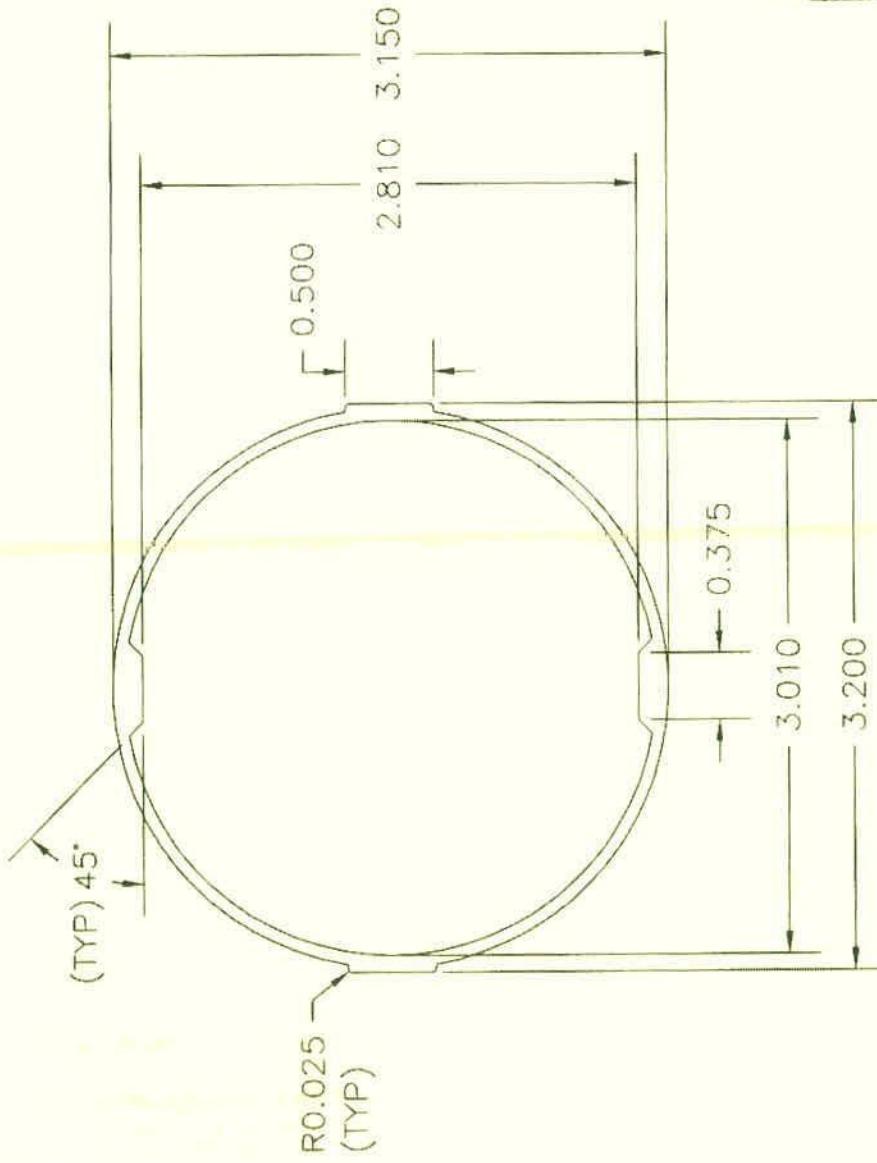
MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR FROM L DIE # Q7112 (REFERRED HERE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH
Eg. D2600-3-120 (120 mm)





DART

DESIGN <i>BB</i>	DRAWN BY <i>JH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JH</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 D'sD2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR RON L DIE # 277121 (PREFERRED CHOICE)

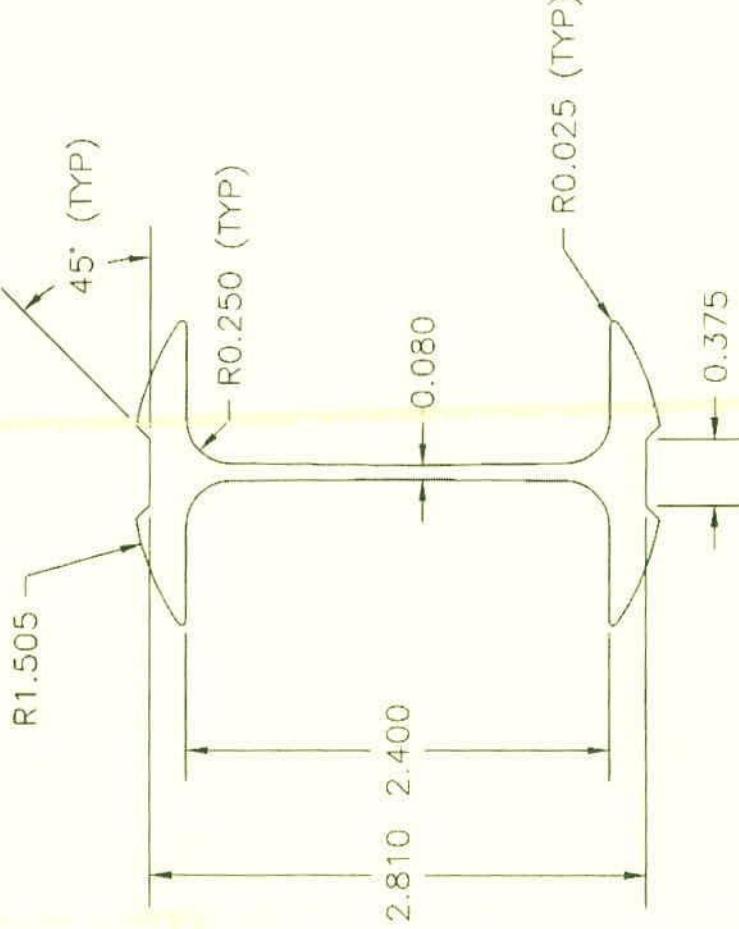
PART NUMBER 1: D2600-1-VXX WHERE VXX IS THE LENGTH IN INCHES / E.G. D2600-1-1000 = 1000 mm (1.600 inch)





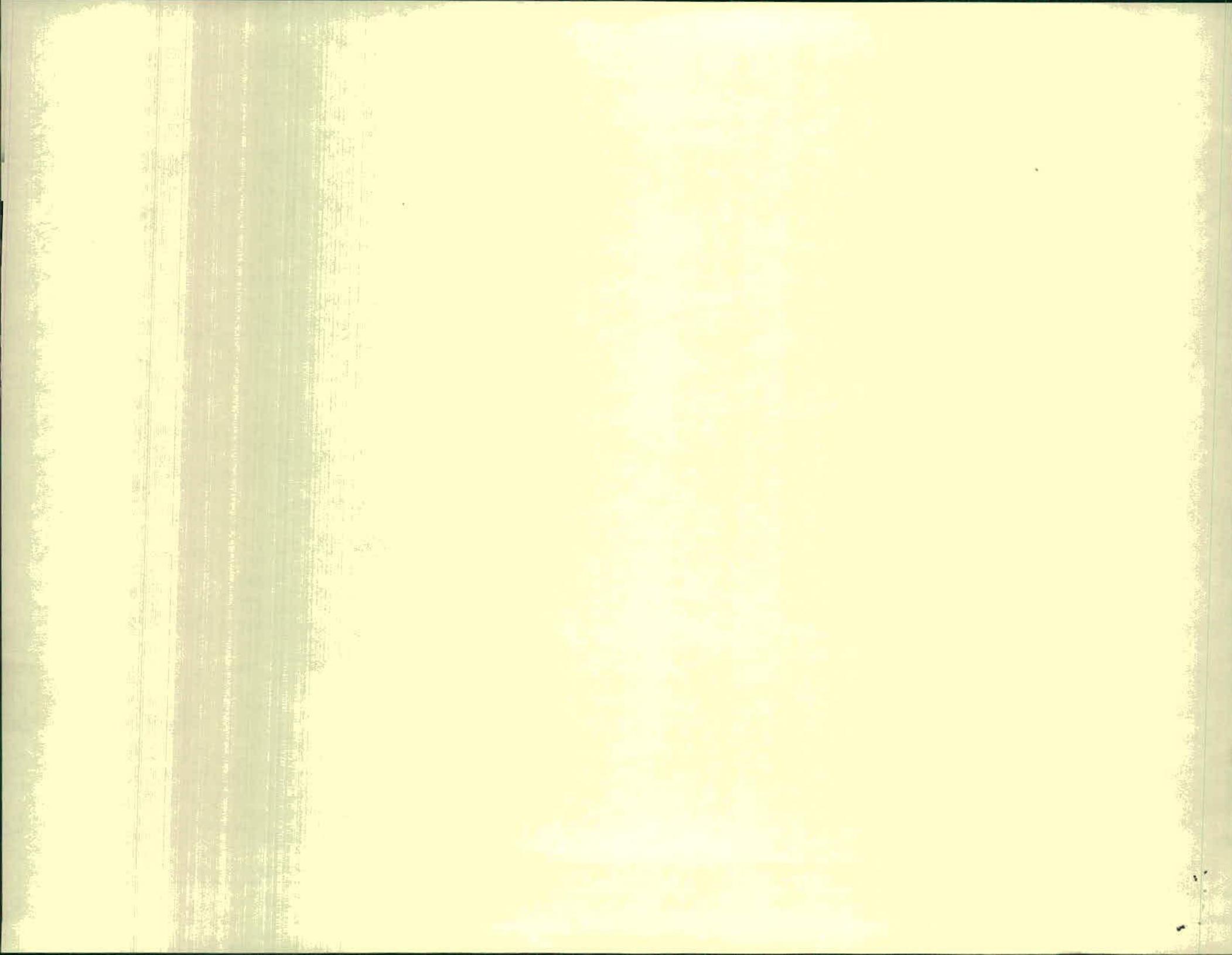
DART

DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>KE</i>	APPROVED <i>RS</i>	DRAWING NO. D2600	REV. D	SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1	

RELEASED
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS PART LENGTH IN INCHES
(Ex. D2600-7-125 IS 125" Long)





DART

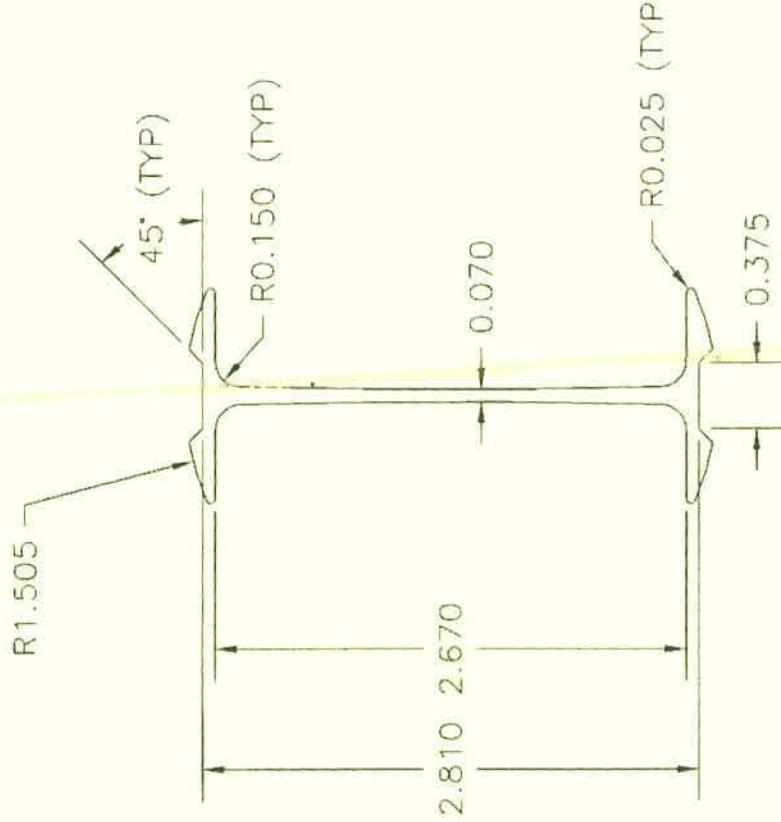
DESIGN <i>MP</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2600
DATE 98.08.20		TITLE EXTRUSION

REV. D

SHEET 4 OF 5

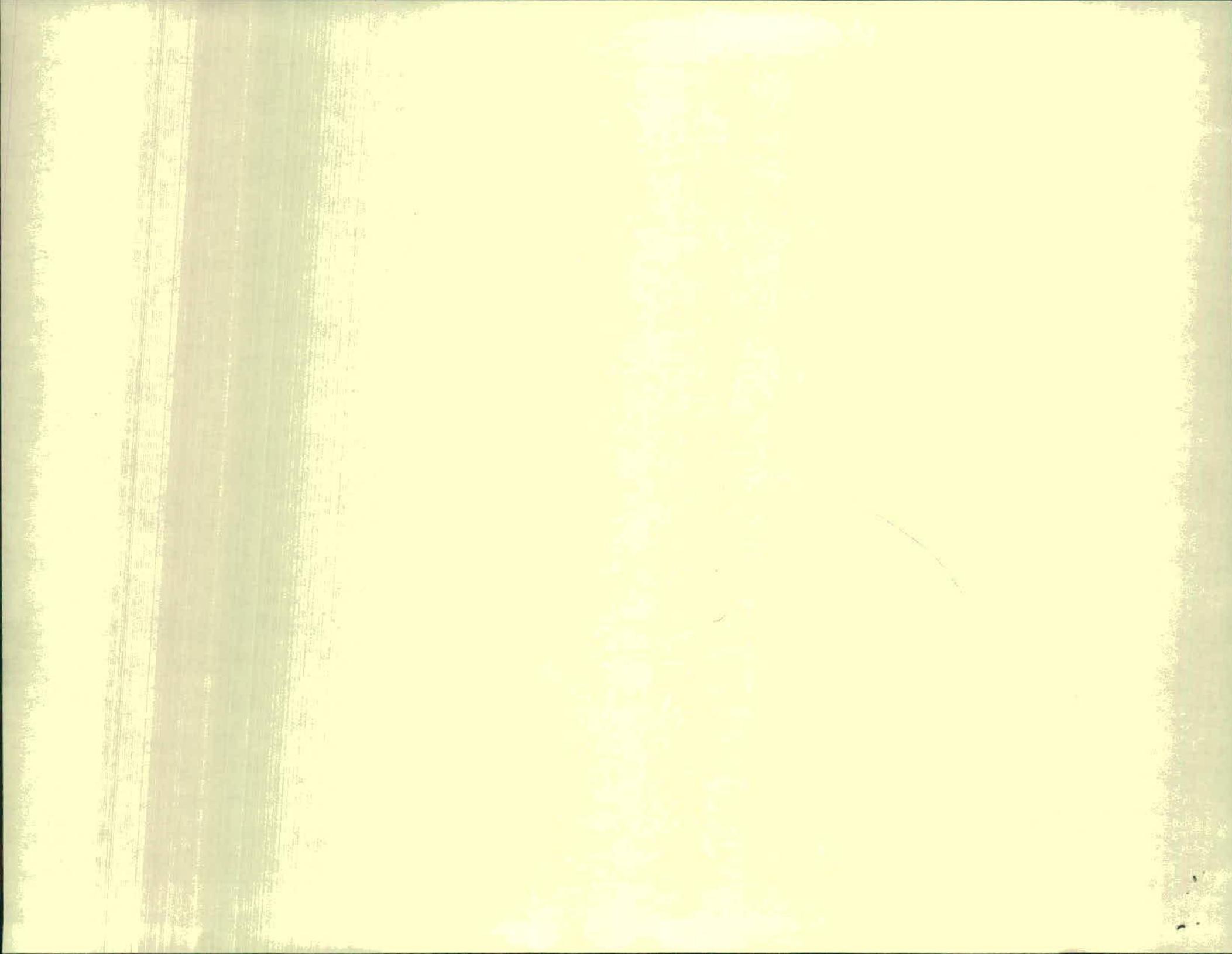
SCALE

1:1

RELEASED
98 8 25 DSD2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS DESIGN-S-XXX WHERE XXX = CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)





CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cart Date	Cert No	Sales Order	Page
09/28/07	166771	87236	1
Cust PO	B/L No	Lot	Date
4623	00359007	87236010	9/28/07

Sold To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7
Item No	
1.000 DAA-897121-1 160" Mill 6061 T6	
Gross Weight	
623 KGS	
Net Qty	
603 KG 98 PC 398 M 2 PKG	
Specification	
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	316.6 / 45.9	289.7 / 42.0	10.2	.0	94

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.66	.24	.28	.05	.89	.05	.007	.07	.000	.009	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

St. 10/03



